



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4276-1

Job Sheet 175434



Part No: D4276-1

Job Qty: 5 ea

Part Name: Aft Beam



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/4/18

Job Tracking No:

Due Date: 4/16/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG REV A IPP REV:A NEW ISSUE 10-11-17 JLM VERIFIED BY:DD IPP rev:B 10.12.02 AS PER DWG
REV.A DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea	4/13/18	4/13/18	0.00	0.00	Start Up Machining-2		<i>mm</i>
100	Bandsaw	5 pcs	4/13/18	4/13/18	0.00	0.08	Bandsaw1		<i>mm</i>
110	CNC Vertical Machining	5 pcs	4/14/18	4/14/18	0.58	8.93	HAAS1-4		<i>mm</i>
120	QC	5 pcs	4/14/18	4/14/18	0.00	0.00	QC2 Machining-2		<i>mm</i>
130	QC	5 pcs	4/14/18	4/14/18	0.00	0.00	QC8 Machining-2		<i>mm</i>
140	HandFinish	5 pcs	4/14/18	4/14/18	0.00	0.59	HandFinish1		<i>SA 18-05-17</i>
145	Powdercoat	5 pcs	4/16/18	4/16/18	0.00	0.45	Powdercoat1		<i>DR 18-05-17</i>
150	QC	5 pcs	4/16/18	4/16/18	0.00	0.00	QC3		<i>SA 18-05-17</i>
180	Packaging	5 pcs	4/16/18	4/16/18	0.00	0.00	Packaging3-2		<i>SA 18-05-17</i>
190	QC21-SA	5 Ea	4/16/18	4/16/18	0.00	0.00	QC21		<i>SA 18-05-17</i>

Part Op 100 - Cut Blank to 36.630"

Descriptions: 110 - 1-Machine per folio FB007

145 - MASK AS PER DWG

1138839

START 10:30

CV.T. 320° FINISH 11:00

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.000X06.000	6061T6 Bar 1.00 X 6.00	15.2600 ft (3.052 ea)	90-Start up Operation	

346056025
2x 3056025

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B1.000X06.000	15	68	0

Part Specifications

Specifications could not be found.

Plex 4/4/18 11:18 AM Dart.Gagnon.Michelle

DART
AEROSPACE

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CANADA
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Container No: S069545



Part: D4276-1

Job No: 175434

Serial No/Batch: S069545

Revision:

Inspector:

Date: 05/08/18

DART AEROSPACE LTD		Work Order: 175434
Description: Aft Beam		Part Number: D4276-1
Inspection Dwg: D4276	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.75	+/-0.030					
20.500	+/-0.010					
Ø0.381	+0.000/-0.001					
14.380	+/-0.010					
R0.75	+/-0.030					
3.50	+/-0.030					
16.38	+/-0.030					
5.00	+/-0.030					
0.75	+/-0.030					
2.75	+/-0.030					
3.00	+/-0.030					
1.250	+/-0.010					
4.50	+/-0.030					
0.734	+/-0.010					
0.108	+/-0.010					
36.38	+/-0.030					
0.95	+/-0.030					
0.60	+/-0.030					
2.70	+/-0.030					
1.10	+/-0.030					
1.25	+/-0.030					
0.75	+/-0.030					
3.000	+/-0.010					
1.500	+/-0.010					
Ø0.191	+0.005/-0.001					
2.300	+/-0.010					
3.50	+/-0.030					
R0.60	+/-0.030					
1.70	+/-0.030					
0.65	+/-0.030					

Measured by:	Audited by:	Preliminary Approval:
Date:	Date:	Date:

Rev	Date	Change	Revised by	Approved
A	11.08.22	New Issue	KJ	M